

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028990**Date Inspected:** 11-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** See Body of Report**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Matthew Daggett was at the American Bridge/Fluor (ABF) job site at the San Francisco/Oakland Bay Bridge in California between the times noted above in order to perform clerical support tasks in the office, and to monitor Quality Control functions and the in process work being performed by ABF personnel:

This QAI observed the welder Mike Jiminez grinding to a bright clean metal condition base metal gouges, in the Deck Plate at the following locations:(RWR 201301-19)

PP123.5-E2.9

PP124.5-E3.0

PP124.5-E3.1

PP124-E3.2

PP124.3-E3.45

Prior to welding, Quality Control Technician Sal Merino, performed Visual and Magnetic Particle Testing on the above base metal gouges. This Quality Assurance Inspector verified the results of the test. No indications were noted.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The welder spent part of the shift depositing the root passes and fill passes with approximately 100% being completed at the end of the shift. Quality Control Technician Sal Merino was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D15-1001R Rev 0 and supporting Procedure Qualification Records (PQR). Prior to and during the welding at this location the QC inspector observed the preheat temperature using a Raytek non-contact Thermometer, was sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature indicating crayon) the pre-heat was then verified by this QA inspector to be greater than 150F. Using a Fluke brand Tong style meter, the parameters were verified to be 115 amps.

13E-PP119 (CCO-238)

This QAI observed Rick Clayborn grinding and laying out the eight locations at 13E-PP119. The stiffeners were delivered on to the project palletized in sets (see attached picture) upon test fit it was discovered that the stiffeners were not beveled correctly. At the time of this report the Contractor has decided to order replacement material.

Summary of Conversations:

See body of report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
